



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2665-2**Job Sheet 208763****Part No:** D2665-2**Job Qty:** 10 pcs**Part Name:** Saddle, RH, Fwd, Aft, Out**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/1/20**Job Tracking No:****Due Date:** 5/11/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	10 pcs	5/9/20		1.00	21.61	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	10 pcs	5/9/20		0.00	1.07	Conventional Mill - 1 - B4B		
							Conventional Mill - 2 - B4B		
120	QC 2	10 pcs	5/9/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S273344**Part:** D2665-2**Job No:** 208763**Serial No/Batch:** S273344**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Date: 04/26/20

						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	DIP 20-04-28
						QC 2 - 69	
						QC 2 - 76	
						QC 2 - 86	
	130 QC 8	10 pcs	5/9/20	0.00	0.00	QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
	140 Handfinish - 1-1 Chemical-B4B	10 pcs	5/9/20	0.00	0.78	QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	VH 20/4/29
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
						QC 8 - 66	
						Handfinish - 1 - 1 - B4B	BEB 20-04-29
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	

				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)- B4B	10 pcs	5/11/20	0.00 0.46	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	10 pcs	5/11/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
					QC 3 - 82
					QC 3 - 87
170	Packaging 3-1 - Stock - B4B	10 pcs	5/11/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
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				Packaging 3 - 24 - B4B	
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				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	10 pcs	5/11/20	0.00 0.00	QC 21 - SA - 21	DAS MAY 01 2020
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-30
Part Op 100 - HAAS CNC Vertical Machine - 1- Program batch number 2- Machine Step # 1 of Folio and visually inspect as per Descriptions: attached Dimension Sheet 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step # 3 of Folio and visually inspect as per attached 110 - Manufacture as per dwg Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-003	Saddle Billet, 7075	10 pcs (1 ea)	100-HAAS 4 Axis	S272 967	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	D6101-003	10	36	0	
Part Specifications					
Specifications could not be found.					

Plex 4/1/20 8:14 AM Dart.lajeunesse.marie

208763
08750

DART AEROSPACE LTD		Work Order:
Description: 206 Saddle, Outboard, Right side		Part Number: D2665-2
Inspection Dwg: D2665 Rev: D DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.121	.120	.120	.120	.120
B	0.100	0.140		.125	.125	.125	.124	.124
C	1.125	1.145		1.135	1.135	1.135	1.135	1.135
D	0.615	0.685		.670	.670	.665	.665	.670
E	0.240	0.260		.249	.248	.248	.248	.248
F	1.313	1.343		1.321	1.321	1.321	1.322	1.321
G	0.210	0.230		.220	.219	.220	.220	.220
H	0.100	0.180		.128	.130	.128	.130	.132
I	2.470	2.510		2.493	2.493	2.493	2.493	2.493
J	1.565	1.585		1.575	1.575	1.575	1.575	1.575
K	0.235	0.240		.238	.238	.238	.238	0.239
L	0.100	0.120		.113	.113	.113	.113	0.113
M	0.990	1.010		1.004	1.003	1.003	1.003	1.003
N	0.510	0.515		.510	.510	.510	.510	0.511
O	5.990	6.010		6.003	6.002	6.002	6.002	6.002
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.312	0.318		.313	.313	.313	.313	0.313
S	0.315	0.322		.316	.316	.316	.316	.316
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		.795	.795	.795	.795	.795
W	0.540	0.560		.550	.550	.550	.549	.550
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		.258	.258	.258	.258	.258
Z	0.912	0.932		.923	.922	.923	.923	.922
AA	0.490	0.510		.503	.504	.504	.502	0.503
AB	0.178	0.198		.188	.188	.188	.188	.188
AC								
AD								
AE								
Accept/Reject								

Measured by: SBL	Date: 20-04-27
Audited by: VRS	Date: 20/4/29
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	M

208763

DART AEROSPACE LTD		Work Order:	208750
Description: 206 Saddle, Outboard, Right side		Part Number:	D2665-2
Inspection Dwg: D2665 Rev: D DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	7 286	8 38	9 48	10 5
A	0.100	0.140		120	120	121	0.121	0.120
B	0.100	0.140		125	0.123	0.124	0.123	0.123
C	1.125	1.145		1.135	1.135	1.135	1.135	1.135
D	0.615	0.685		0.670	0.665	0.665	0.685	0.685
E	0.240	0.260		0.248	0.248	0.247	0.248	0.246
F	1.313	1.343		1.322	1.321	1.322	1.322	1.322
G	0.210	0.230		0.222	0.220	0.220	0.220	0.219
H	0.100	0.180		0.132	0.132	0.132	0.133	0.133
I	2.470	2.510		2.493	2.493	2.493	2.495	2.495
J	1.565	1.585		1.575	1.575	1.575	1.575	1.575
K	0.235	0.240		0.239	0.239	0.239	0.239	0.239
L	0.100	0.120		0.113	0.113	0.113	0.113	0.113
M	0.990	1.010		1.004	1.004	1.004	1.004	1.004
N	0.510	0.515		0.511	0.511	0.511	0.511	0.511
O	5.990	6.010		6.002	6.002	6.001	6.001	6.001
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.312	0.318		0.313	0.313	0.313	0.313	0.313
S	0.315	0.322		0.316	0.316	0.316	0.316	0.316
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		0.795	0.796	0.795	0.796	0.796
W	0.540	0.560		0.550	0.551	0.549	0.548	0.548
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		0.258	0.258	0.258	0.258	0.258
Z	0.912	0.932		0.923	0.924	0.923	0.923	0.923
AA	0.490	0.510		0.505	0.504	0.505	0.504	0.504
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AC								
AD								
AE								
Accept/Reject								

Measured by:	<i>[Signature]</i>	Date:	20-04-28
Audited by:	<i>[Signature]</i>	Date:	20/4/29
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
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G	12.03.08	Dimension R and Y revised	KJ	<i>[Signature]</i>

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION	Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐	DEPARTMENT/PROCESS	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																																																								
Date : _____		Sequence #: _____		QTY Affected : _____																																																																								
Description Work Order Deviation		Disposition																																																																										
Root Cause <table style="width: 100%;"> <tr> <td>Operator</td> <td>☐</td> </tr> <tr> <td>Manufacturing Process</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> </tr> <tr> <td>Handling/Preservation</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> </tr> <tr> <td>Product Improvement</td> <td>☐</td> </tr> <tr> <td>Process Improvement</td> <td>☐</td> </tr> <tr> <td>Human Factors</td> <td>☐</td> </tr> </table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table style="width: 100%;"> <tr> <td>Pressure/Forced</td> <td>☐</td> <td>Contamination</td> <td>☐</td> <td>Power Loss/Surge</td> <td>☐</td> <td>Positioned Wrong</td> <td>☐</td> </tr> <tr> <td>Bending</td> <td>☐</td> <td>Misaligned/off center</td> <td>☐</td> <td>Folio/Program</td> <td>☐</td> <td>Outside Tolerance</td> <td>☐</td> </tr> <tr> <td>Crushing</td> <td>☐</td> <td>BOM/Route</td> <td>☐</td> <td>Grain Direction</td> <td>☐</td> <td>Drawing</td> <td>☐</td> </tr> <tr> <td>Cracks</td> <td>☐</td> <td>Broken/Damage/Defect</td> <td>☐</td> <td>Weld</td> <td>☐</td> <td>Finish</td> <td>☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>☐</td> <td>Incomplete/Unclear Instructions</td> <td>☐</td> <td>Wrong Stock Pulled</td> <td>☐</td> <td>Part Lost/Missing</td> <td>☐</td> </tr> <tr> <td>Marks/Chatter</td> <td>☐</td> <td>Drill Holes</td> <td>☐</td> <td>Out of Sequence</td> <td>☐</td> <td>Misread</td> <td>☐</td> </tr> <tr> <td>Mislabeled</td> <td>☐</td> <td>Fit/Function</td> <td>☐</td> <td>Off-set/Set-up</td> <td>☐</td> <td></td> <td></td> </tr> </table>			Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		
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		Lead hand / Supervisor _____																																																																										
		QC / QA Coordinator _____																																																																										